

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009151**Date Inspected:** 18-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	Xu Xian Ping		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No
Rod Oven in Use:	Yes	No
Weld Procedures Followed:	Yes	No
Verified Joint Fit-up:	Yes	No
Approved WPS:	Yes	No
Delayed / Cancelled:	Yes	No
Component:	OBG & TOWER Components	

Bridge No: 34-0006**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Sandeep Kumar was present during the times noted above for observations relative to the work being performed.

BAY 1

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #001 located on Counter Weight CW002B – PP080. Welder is identified as 219189. ZPMC QC is identified as Tian Lei. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2133.

BAY 2

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #011 located on Floor Beam FB3083 – 002. Welder is identified as 062438. ZPMC QC is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the

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WPS – B – T – 2132 – 3.

FCAW process welding of weld joint #047 located on Floor Beam FB3094 – 001. Welder is identified as 206358. ZPMC QC is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2233 – Tc – U4b – F.

FCAW process welding of weld joint #036 located on Floor Beam FB3083 – 003. Welder is identified as 045203. ZPMC QC is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2133.

FCAW process welding of weld joint #039 located on Floor Beam FB3022 – 001. Welder is identified as 215676. ZPMC QC is identified as Yang Qing Feng. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2233 – Tc – U4b – F.

BAY 3

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #003 located on Longitudinal Diaphragm LD003 – 056. Welder is identified as 051356. ZPMC QC is identified as Yin Dong Hai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132 – 3.

SMAW process welding of weld joint #006 located on Longitudinal Diaphragm LD001 – 047. Welder is identified as 044304. ZPMC QC is identified as Yin Dong Hai. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2112.

FCAW process welding of weld joint #008 located on Longitudinal Diaphragm LD003 – 056. Welder is identified as 051356. ZPMC QC is identified as Yin Dong Hai. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2133.

BAY 5

Magnetic Particle Testing

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows:

1. 11TR2 – 013 – 004
2. 11TR2 – 015 – 004
3. 11TR2 – 002 – 002
4. 11TR2 – 001 – 002
5. 11TR2 – 004 – 002

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6. 11TR2 – 005 – 002

7. TR7B – PP8.5 – 001 ~ 005 (Weld repair areas on base material)

8. TR8B – PP8.5 – 001 ~ 005 (Weld repair areas on base material)

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #003 located on Traveler Rail Bracket TR5B – PP085. Welder is identified as 066064. ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U4c – F.

FCAW process welding of weld joint #003 located on Traveler Rail 11TR1 – 029. Welder is identified as 217805. ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – B – U2 – F.

FCAW process welding of weld joint #003 located on Traveler Rail Bracket TR5B – PP061. Welder is identified as 068858. ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U4c – F.

FCAW process welding of weld joint #004 located on Traveler Rail 11TR2 – 018. Welder is identified as 215689. ZPMC QC is identified as Zhong Chong Biao. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2231 – B – U2 – F.

BAY 6

This QA Inspector observed the following work in progress:

TOWER

SMAW process welding of weld joint #7A located on WD1 – A305 – 77M – 1. Welder is identified as 053753. ZPMC QC is identified as Su Zhen Rong. The welding variables recorded by QC appeared to comply with the WPS – 485 – SMAW – 2G (2F) FCM – Repair – 1.

SMAW process welding of weld joint #1A located on WD1 – A305 – 65M – 2. Welder is identified as 049769. ZPMC QC is identified as Su Zhen Rong. The welding variables recorded by QC appeared to comply with the WPS – 485 – SMAW – 2G (2F) FCM – Repair – 1.

SMAW process welding of weld joint #2A located on WD1 – A305 – 77M – 4. Welder is identified as 067707. ZPMC QC is identified as Su Zhen Rong. The welding variables recorded by QC appeared to comply with the WPS – 485 – SMAW – 2G (2F) FCM – Repair – 1.

SMAW process welding of weld joint #8A located on WD1 – A305 – 65M – 2. Welder is identified as 048659. ZPMC QC is identified as Su Zhen Rong. The welding variables recorded by QC appeared to comply with the WPS – 485 – SMAW – 2G (2F) FCM – Repair – 1.

SMAW process welding of weld joint #8B located on WD1 – A305 – 77M – 4. Welder is identified as 053753.

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ZPMC QC is identified as Su Zhen Rong. The welding variables recorded by QC appeared to comply with the WPS – 485 – SMAW – 2G (2F) FCM – Repair – 1.

Cross Beam - 9

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #019 located on Cross Beam CB202A – 009. Welder is identified as 048625.

ZPMC QC is identified as Liu Chuan Gang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2132.

FCAW process welding of weld joint #069 located on Floor Beam FB204 – 021. Welder is identified as 053609.

ZPMC QC is identified as Liu Chuan Gang. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2232 – Tc – U4b – F.

SMAW process welding of weld joint # 143 / 161 located on Cross Beam CB202G – 022. Welder is identified as 070007. ZPMC QC is identified as Liu Chuan Gang. The welding variables recorded by QC appeared to comply with the WPS – B – P – 2113.

BAY 7

This QA Inspector observed the following work in progress:

FCAW process welding of weld joint #031 located on Side Plate SP3026 – 017. Welder is identified as 051246.

ZPMC QC is identified as Zhong Dian Xing. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2233 – Tc – U4b – F.

FCAW process welding of weld joint #052 located on Side Plate SP3026 – 017. Welder is identified as 051246.

ZPMC QC is identified as Zhong Dian Xing. The welding variables recorded by QC appeared to comply with the WPS – B – T – 2233 – Tc – U4b – F.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No Relevant Conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang - 15000422372, who represents the Office of Structural Materials for your project.

Inspected By: Kumar,Sandeep

Quality Assurance Inspector

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Reviewed By: Prue,Erik

QA Reviewer